



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

002752

648.4703
Job Sheet 176036



Part No: 648.4703

Job Qty: 1 ea

Part Name: C10 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG O&OPM-C10 Rev 4 IPP Rev A 18.03.14 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/26/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Small Fab	1 pcs		4/27/18	0.00	1.00	Small Fab-6		
120	QC	1 pcs		4/27/18	0.00	0.00	QC4		
125	DC	1 pcs		4/27/18	0.00	0.00	DC		
130	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		4/27/18	0.00	0.00	QC21		

Part Op 110 - Pick bag and tag

Descriptions: 125 - Supply owner's & overhaul procedures manual

130 - Identify and pack for shipping as per PPP 647.7303

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1/4 20-3/8	Set Screw	- 2 Ea (2 ea)	90-Start up Operation	5049641
188-FPSS-1032-1/4	Set Screw	- 2 Ea (2 ea)	90-Start up Operation	5010651
188-SHCS-1032-3/4	Bolt	- 8 Ea (8 ea)	90-Start up Operation	5042363
600.1309-A	Label	- 1 Ea (1 ea)	90-Start up Operation	5064514
600.1347	C10 Warning Label	- 1 (1 ea)	90-Start up Operation	5029487
AN4-23A	Bolt	- 2 Ea (2 ea)	90-Start up Operation	F123434 - 40
AN6-31A	Bolt	- 6 Ea (6 ea)	90-Start up Operation	5048403
AN960-416	Flat Washer Dia 1/4"	- 3 Ea (3 ea)	90-Start up Operation	EM127832-25
AN960-416L	Washer	- 2 (2 ea)	90-Start up Operation	5050655
AN960-616L	5/8" OD, THIN FLAT WASHER see NAS1149F0632P	- 12 Ea (12 ea)	90-Start up Operation	5048297
C10-10-2	Actuator Pin	- 1 (1 ea)	90-Start up Operation	5029190
C10-10-3	Actuator Bushing	- 2 (2 ea)	90-Start up Operation	5029191
C10-21-4	Lock Washer	- 8 Ea (8 ea)	90-Start up Operation	5048559-5038404
C10-22	Lock Bumper	- 3 Ea (3 ea)	90-Start up Operation	5063972
C10-23-1	Keeper Spacer	- 1 Ea (1 ea)	90-Start up Operation	5029200
C10-23-2	Keeper Spring	- 1 pcs (1 ea)	90-Start up Operation	5060601
C10-23-3	Keeper Bushing	- 2 (2 ea)	90-Start up Operation	5029201
C10-3	Load Beam Bumper	- 1 Ea (1 ea)	90-Start up Operation	5029204
C10-4-10	Spring Anchor Spring Pin	- 2 (2 ea)	90-Start up Operation	5029208
C10-4-6	Lock Spring	- 1 (1 ea)	90-Start up Operation	5029215
C10-4-7	Spring Retaining Pin	- 1 (1 ea)	90-Start up Operation	5029214
C10-4-8	Lock Bushing	- 2 pcs (2 ea)	90-Start up Operation	5060088

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval						
Description Work Order Dart Aerospace Ltd. 1270 Aberdeen Street Newmarket, ON A6A 1K7 CANADA TEL : 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S064567 Part: 648.4703 Job No: 176036 Serial No/Batch: S064567 Revision: 4 Inspector: Date: 04/24/18				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval						
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 33%;"> Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%;"> Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>				Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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C10-4-9	Upper Roller DU Bearing	1 (1 ea)	90-Start up Operation	5029218
C10-7	Locating Pin	3 (3 ea)	90-Start up Operation	5029220
C10-8	Trunnion Bushing	2 pcs (2 ea)	90-Start up Operation	5029221
C10-9-2	Latch Bearing Torrington	1 Ea (1 ea)	90-Start up Operation	5038782
C10-9-4	Latch Shaft Bearing	2 pcs (2 ea)	90-Start up Operation	5029223
C10-9-6	Latch Return Spring	2 Ea (2 ea)	90-Start up Operation	5046045
C2-14-2	Label Rivets	2 Ea (2 ea)	90-Start up Operation	5040661
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	90-Start up Operation	5060126 5054986
C45-12-6	Retaining Ring	2 Ea (2 ea)	90-Start up Operation	5045041 5054986
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	90-Start up Operation	5060124
MS21044N6	Nut, Self-Lock .375-24,UNJF-3B	6 Ea (6 ea)	90-Start up Operation	5041083
MS21083N4	Nut	2 Ea (2 ea)	90-Start up Operation	504964 5060423
MS27039-4-08	Screw	1 Ea (1 ea)	90-Start up Operation	50132259 5039330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1/4 20-3/8	2	50	0
	188-FPSS-1032-1/4	2	108	0
	188-SHCS-1032-3/4	8	300	0
	600.1309-A	1	0	0
	600.1347	1	0	0
	AN4-23A	2	614	0
	AN6-31A	6	30	0
	AN960-416	3	0	0
	AN960-416L	2	0	0
	AN960-616L	12	0	0
	C10-10-2	1	0	0
	C10-10-3	2	0	0
	C10-21-4	8	92	0
	C10-22	3	0	0
	C10-23-1	1	0	0
	C10-23-2	1	62	0
	C10-23-3	2	0	0
	C10-3	1	0	0
	C10-4-10	2	0	0
	C10-4-6	1	0	0
	C10-4-7	1	0	0
	C10-4-8	2	25	0
	C10-4-9	1	0	0
	C10-7	3	0	0
	C10-8	2	0	0
	C10-9-2	1	11	0
	C10-9-4	2	0	0
	C10-9-6	2	21	0
	C2-14-2	2	274	0
	C3-12-6	2	17	0
	C45-12-6	2	58	0
	C45-8-4	1	16	0
	MS21044N6	6	36	0
	MS21083N4	2	32	0
	MS27039-4-08	1	91	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								